

Date: Friday, 14/07/2006 2:46:00 PM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CABLE GUARD
Job Number	: 27906		
Estimate Number	: 12458		
P.O. Number	: N/A	Part Number	: D29165
This Issue	: 14/07/2006 S.O. No. : N/A	Drawing Number	: D2916 REV B
Prsht Rev.	: NC	Project - Number	: N/A
First Issue	: 13/07/2006 Type : MACHINED PARTS	Drawing Revision	: B
Previous Run		Material	: N/A
Written By	: <u>See comment below</u>	Due Date	: 10/08/2006 Qty: 10 Um: Each
Checked & Approved By	: <u>[Signature]</u>		
Comment	: Est Rev:A New Issue 06-06-19 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET		
2.0	MUHMWB10	UHMW 1" Black
Comment: Qty.: 0.4000 sf(s)/Unit Total : 4.0000 sf(s) UHMW 1" Black <u>Batch # 101254</u> <u>SAD</u> <u>06:08:16</u> <u>10</u>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>SAD</u> <u>06:08:16</u> <u>10</u>		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK <u>JML</u> <u>06/08/15</u> <u>10</u>		
5.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS CNC VERTICAL MACHINING #1 BATCH: <u>M101253</u> 1- Mill as per Folio FA2916-5 Rev: <u>A</u> & Dwg D2916 Rev: <u>B</u> 2-Deburr per dwg D2916 <u>JML</u> <u>06/08/15</u> <u>10</u>		

Date: Friday, 14/07/2006 2:46:00 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters' Services

Drawing Name: CABLE GUARD

Job Number: 27906

Part Number: D29165

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

me 06/08/15

10

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.L 06/08/15

(10)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

51373

W RB 06/08/16

(10)

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



C Loe 10/08/17

Date: Thursday, 7/13/2006 3:38:18 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CABLE GUARD
Job Number	: 27906		
Estimate Number	: 12458		
P.O. Number	:	Part Number	: D29165
This Issue	: 7/13/2006 S.O. No. :	Drawing Number	: D2916 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	:	Material	:
Written By	: <u> </u>	Due Date	: 8/10/2006 Qty: 10 Um: Each
Checked & Approved By	: <u> </u>		
Comment	: Est Rev:A New Issue 06-06-19 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: _____

For (1) D2916-5 32.29" x 1.75" x 1.00" (

Tolerance for all measurements is (+0.030/-0.000)

Material: Black UHMW(MUHMWB10)

Possible Supplier: GE PolymersMaterial release note is required

cut on waterjet

MUHMWB10

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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3.0



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

3.0	QC6	DIMENSIONAL CHECK
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2.0



Comment: DIMENSIONAL CHECK

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

BATCH: _____

1- Mill as per Folio FA2916-5 Rev: _____ & Dwg D2916 Rev: _____

2-Deburr per dwg D2916

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 7/13/2006 3:38:19 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CABLE GUARD

Job Number: 27906

Part Number: D29165

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

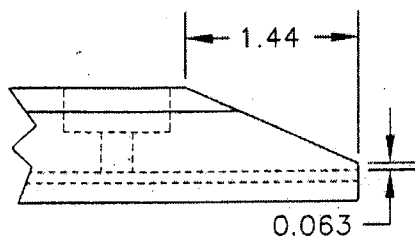
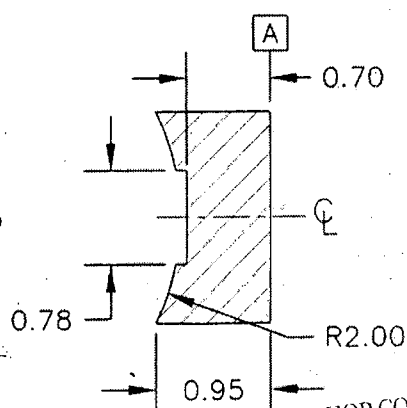
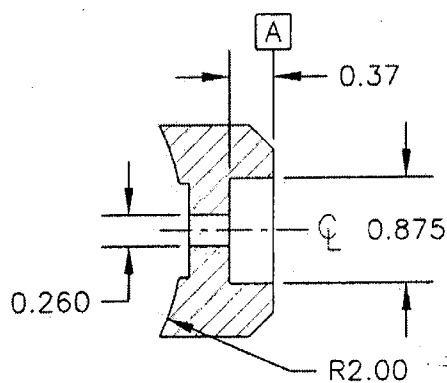
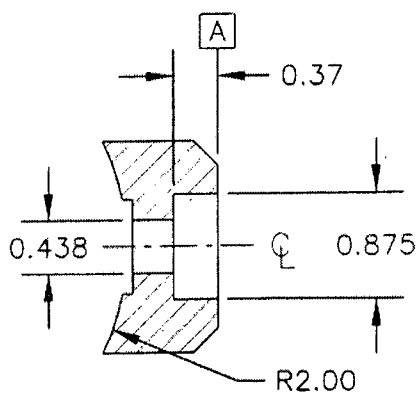
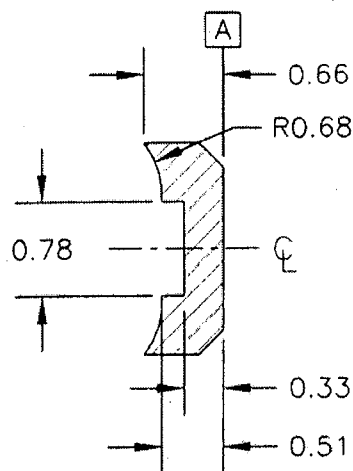
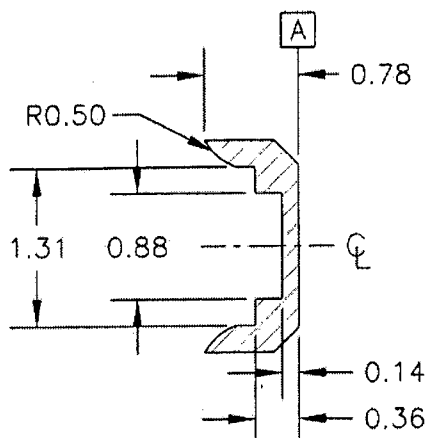
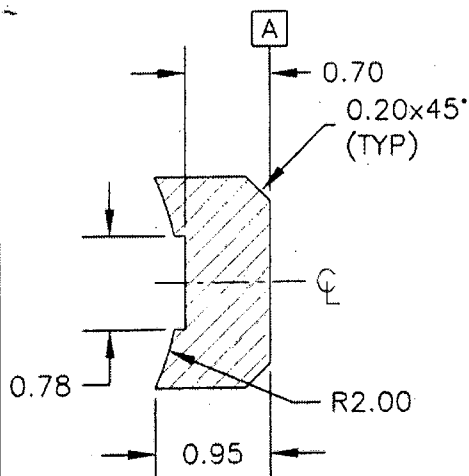
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

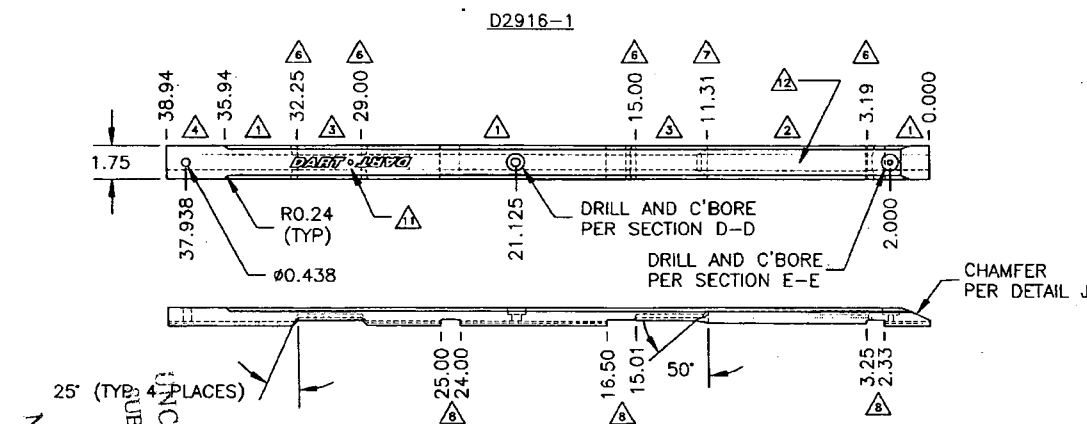
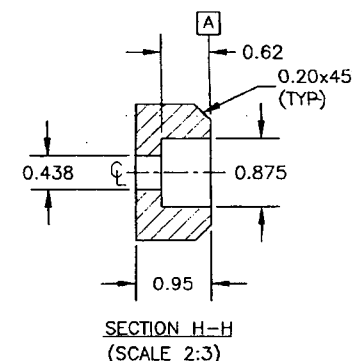
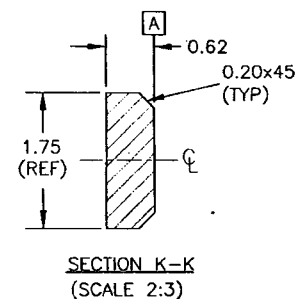
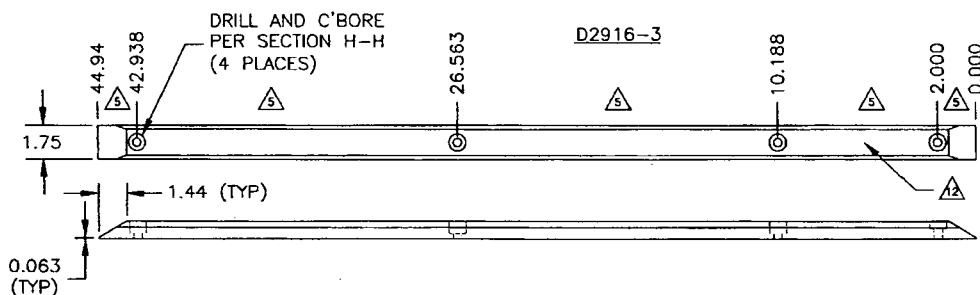
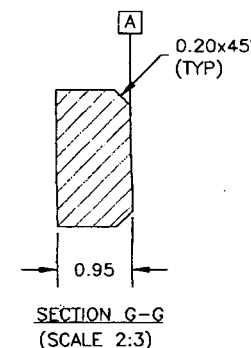
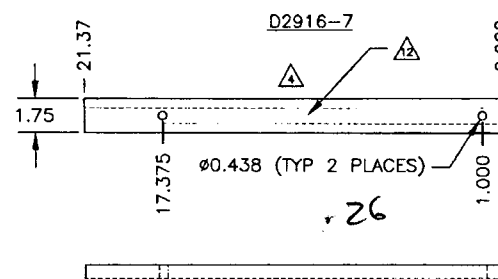
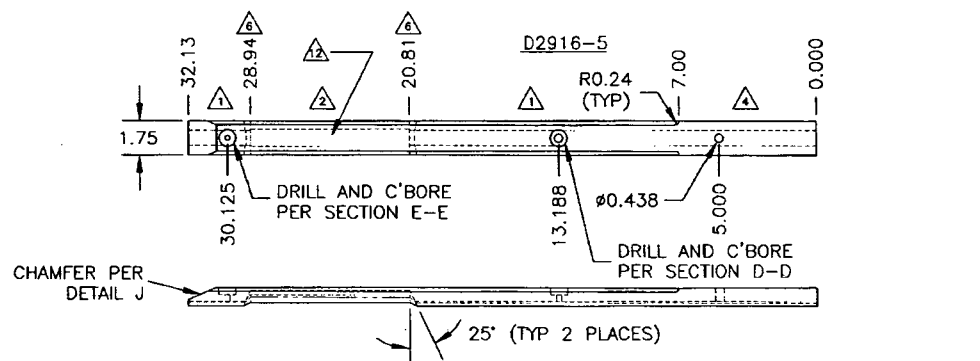


DESIGN #	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2916	REV. B SHEET 1 OF 2
DATE 00.02.24		TITLE CABLE GUARD	SCALE 1:6
A	99.09.29	NEW ISSUE	
B	00.02.24	ADD K-K FOR D2521 COMPATIBILITY	



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WORK ORDER
NO. 27906

RELEASED
00.02.25 DS



- NOTES:
- 1) MACHINE CONSTANT SECTION A-A
 - 2) MACHINE CONSTANT SECTION B-B
 - 3) MACHINE CONSTANT SECTION C-C
 - 4) MACHINE CONSTANT SECTION F-F
 - 5) MACHINE CONSTANT SECTION G-G
 - 6) 25° ANGLE OF TRANSITION BETWEEN SECTIONS WITH MIN RADIUS OF 0.50
 - 7) 50° ANGLE OF TRANSITION BETWEEN SECTIONS WITH MIN RADIUS OF 0.50
 - 8) MACHINE SLOT PER SECTION K-K WITH 0.063 RADIUS OF TRANSITION BETWEEN SECTIONS
 - 9) MATERIAL: UHMW BLACK PER SPEC CONTROL DWG D2689
 - 10) BREAK ALL UNMARKED RADII 0.020 TO 0.040
 - 11) ENGRAVE TWO DART LOGOS (OPPOSITE AS SHOWN) ON UPPER SIDE TO MAX DEPTH OF 0.015 AND MIN RADIUS OF 0.250.
 - 12) ENGRAVE P/N ON LOWER SIDE TO MAX DEPTH OF 0.010 AND MIN RADIUS OF 0.010.
 - 13) ALL HOLES DRILLED ON CENTERLINES
 - 14) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 15) ALL DIMENSIONS ARE IN INCHES

RELEASED

DESIGN #	DRAWN BY P	DART DART AEROSPACE LTD WILLOWDALE, ONTARIO, CANADA	REV. B
CHECKED #	APPROVED #	DRAWING NO. D2916	SHEET 2 OF 2
DATE 00.02.24		TITLE CABLE GUARD	SCALE 1:6

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NO. 27906
WORK ORDER
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DART AEROSPACE LTD		Work Order: 27906
Description:		Part Number: D29165
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.75	± 0.030	1.749	✓		Vern	
32.13	± 0.030	32.125	✓		Measuring tape Vern	
1.00	± 0.030	1.020	✓		Vern	
.140"	$\pm .030$ "	.130"	✓			
.360"	$\pm .030$ "	.355"	✓			
.780"	$\pm .030$ "	.782	✓			
.700"	$\pm .030$ "	.699"	✓			
.950"	$\pm .030$ "	.943"	✓			
.780"	$\pm .030$ "	.810"	✓			
20 x 45°	$\pm .030$ "	.200"	✓			
1.310"	$\pm .030$ "	1.290"	✓			
.88	$\pm .030$ "	.871"	✓			
.370"	$\pm .030$ "	.374"	✓			
.875"	$\pm .010$ "	.874"	✓			
Ø .438"	$\pm .001$ "	Ø .437"	✓			
Ø .260"	$\pm .001$ "	Ø .259"	✓			
1.44"	$\pm .030$ "	1.44"	✓			
.063"	$\pm .010$ "	.073"	✓			
5.000"	$\pm .010$ "	5.007"	✓			

Measured by: JAD	Audited by: J.G	Prototype Approval: N/A
Date: 06/08/10	Date: 06/08/10	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	